

**ABSTRACT OF THE DISCLOSURE**

A machining center, especially a self-loading machining center has a plurality of machining devices and an automatic tool-replacement system. The transport device delivers a workpiece to and receives a workpiece from a workpiece holder on a machine base between longitudinal rails on which the workpiece holder is guided. The workpiece holder carries the workpieces into the operating ranges of a pair of machining devices which can be shifted from the machining position into the tool-change position alternately. The machining feed is provided by the workpiece holder.

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